

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009016**Date Inspected:** 16-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (Lift 1 West)

This QA inspector performed dimensional check on PP 12 stiffeners on side panel – Counterweight side and the measurements recorded to verify the below requirements. This inspection carried out on advice of OBG SMR.

Distance from reference point

Verticality

Cutout to top of stiffener

Cutout to bottom of stiffener

Cope hole size

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD- (1AAW-1AW)

FCAW Process:

Welding of weld joint –053 and 054 located on PCMK OBW1. Welder is identified as 220063

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ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

OBG # TRIAL ASSEMBLY YARD- (5BE)

SMAW Process:

Welding of weld joint –035 located on PCMK SEG024A. Welder is identified as 037780
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-B-U2-FCM-1

OBG # TRIAL ASSEMBLY YARD- (5CE)

SMAW Process:

Welding of weld joint –022 located on PCMK CA023. Welder is identified as 037780
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-B-U2-FCM-1

OBG # TRIAL ASSEMBLY YARD- (5BW)

SMAW Process:

Welding of weld joint –169 located on PCMK SSD12A. Welder is identified as 069493
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-F

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
